

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025241**Date Inspected:** 05-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Christopher Concha**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006 L & R**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

E2/E3 Bike Path Traveler

This QA Inspector made random shop observations and observed no fit-up on the E2/E3 Bike Path Traveler Assemblies on this date.

SAS-WB Traveler – Lower Truss Frame Assembly

Welding Completed on the SAS-WB Traveler – Lower Truss Frame Assembly on Thursday 5-12-11. Quality Control Mr. Dominguez informed QA Inspector that Smith Emery did complete visual inspection and waiting on WMI to weld and grind on some area's found by visual inspection. QA Inspector randomly observed WMI personnel grinding pick-up area's found by QC on this date. Pick-up not completed on this date.

E2/E3-WB Traveler

This QA Inspector randomly observed WMI production personnel Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Fuentes performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to

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perform Flux Core Arc Welding (FCAW) activities on the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the am shift.

Elevation Platforms

This QA Inspector randomly observed WMI production personnel Mr. Alberto Cortes WID #3141 and Mr. Charles Newton (WID # 3200) performing layout, fitting and tack welding activities at various locations for the E2/E3-WB Traveler Assemblies. This QA Inspector observed Mr. Cortes performing the FCAW in all positions randomly throughout the shift.

SAS-WB Traveler - Fixed Stair Section

This QA Inspector randomly observed WMI production personnel Mr. Cesar Canales WID #3195 and helper Mr. Jesus Rayas WID#3197, performing layout, fitting and tack welding activities at various locations for the SAS-WB Traveler Assemblies. This QA Inspector observed Mr. Canales performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Christopher Concha was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Mr. Concha verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.

WMI Material Verification

QA Inspector Brannon performed material verification and reviewed applicable documents and verified quantities. After review of the documents and material, QA Inspector assigned Caltrans lot number B208-007-11 for Ok to cut material. See Caltrans Source Inspection Report, TL-6034 dated July 5, 2011 for specific information.

RPI Coating (Blast and Paint)

This QA Inspector was informed by RPI Coating Mr. Carlos Torres that RPI will be onsite to start back on the painting operations today. QA Inspector made random shop observation and noticed that RPI was sanding link assemblies using 100 grit sandpaper on previously prime coated link assemblies to remove excess over spray areas.

QA Inspector asked Mr. Ron Ybarra if RPI was going to start applying the final coat to the link assemblies today. Mr. Ybarra stated that RPI is going to start applying the final top coat today. QA Inspector noticed after RPI started applying final coat QA Inspector had noticed out gassing (fisheyes) in the top coat on most of the link assemblies and that RPI had applied the final coat over areas of mudcracking in the joints today. Note: RPI did not water blast prime coated before applying the final coat and had coated over several areas of mudcracking and areas of on the prime coat that exceeded prime coating thickness requirements per Special Provisions. This QA

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Inspector was informed by RPI Coating Mr. Carlos Torres that RPI will have the Sherman Williams Representative on site tomorrow to help RPI figure out what caused the out gassing (fisheyes) in the top coat applied today. QA Inspector informed SMR Mr. Nicolai Hvass and QA Inspector Mr. Fintan Shanley of the above information.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Brannon, Sherri

Quality Assurance Inspector

Reviewed By: Lanz, Joe

QA Reviewer